

Date: Wednesday, 12/11/2008 1:41:28 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACK PANEL
Job Number : 43393	
Estimate Number : 11093	
P.O. Number :	Part Number : D30231
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D3023 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 42445	Material :
Written By :	Due Date : 05/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.11.12</u>	
Comment : Est. C 02.01.23 Revised NG Est Rev:D 08-04-16 now water jet DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 3.0216 sf(s)/Unit Total : 3.0216 sf(s)
 2024-T3 .032 sheet
 Material: 2024-T3 sheet (QQ-A-250/4) 0.032"
 Batch: 109240 LB 8-11-18

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3023
 Dwg Rev: A LB 8-11-18
 Prog Rev: A
 ****graind direction along 28.100" ****
 2-Deburr if necessary LB 8-11-18



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Soslu 18 20

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Bend as per Dwg D3023

SP 08/11/19



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:41:29 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK PANEL

Job Number: 43393

Part Number: D30231

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-form edge of back pan as per dwg D3023 using D3017-041 back frame

6.0

QC5

INSPECT WORK TO CURRENT STEP



Joe 11-20 @



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JS

08-11-20 (K)

8.0

POWDER COATING

POWDER COATING



M 109648



(1X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:20

OVEN TEMPERATURE:

320 OF

FINISH TIME:

10:50

M-L 08/11/24

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24 (K)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 43345

JS 08/11/24 (K)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/26 JS

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-11-24

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

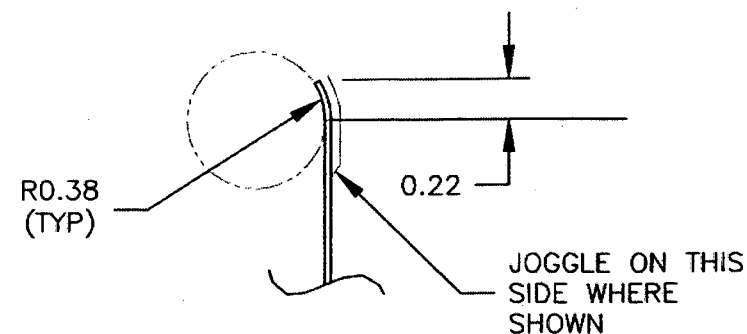
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

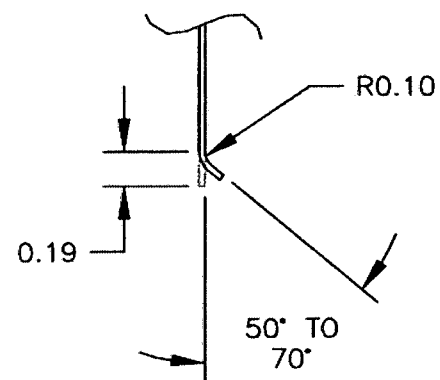
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

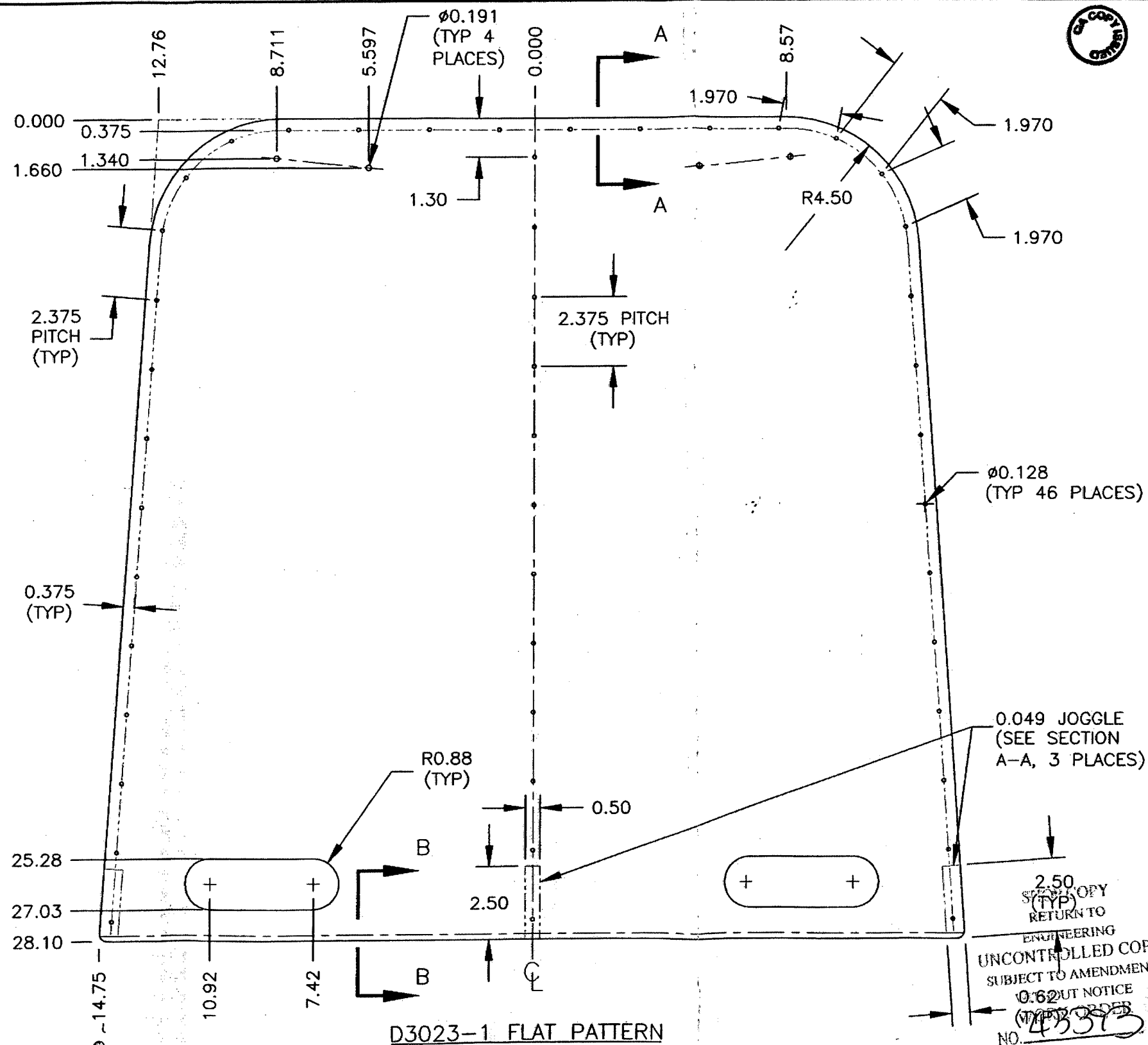


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAWKESSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023 REV. A SHEET 1 OF 1
DATE	TITLE	SCALE
01.05.18	BACK PANEL	1:4

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
0.62 OUT NOTICE
NO. 43373

DART AEROSPACE LTD		Work Order: 43393
Description: BACK PANEL		Part Number: D3023-1
Inspection Dwg: D3023-1, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .005 - .001	.130	X			
Ø .191	+ .005 - .001	.193	X			
1.660	+/- .010	1.661	X			
.375	+/- .010	.375	X			
1.340	+/- .010	1.341	X			
2.375	+/- .010	2.374	X			
.375	+/- .010	.375	X			
25.28	+/- .030	25.28	X			
27.03	+/- .030	27.03	X			
28.10	+/- .030	28.10	X			
1.30	+/- .030	1.298	X			
2.375	+/- .010	2.375	X			
8.711	+/- .010	8.715	X			
5.597	+/- .010	5.600	X			
8.57	+/- .030	8.57	X			
1.970	+/- .010	1.971	X			
7.42	+/- .030	7.422	X			
10.92	+/- .030	10.922	X			
14.75	+/- .030	14.730	X			

Measured by: RB	Audited by: S	Prototype Approval: 1
Date: 8-11-18	Date: 08/11/18	Date: 12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	